



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-646-041

Job Sheet 197064



Part No: D119-646-041

Job Qty: 1 pcs

Part Name: AW119 Replacement Skidtube with Wearpads - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/27/19

Job Tracking No:

Due Date: 4/20/20

Created By: Jennifer Renwick

Type: SOLD

Description: Order 17375

Note: DWG IIN-D119-646 REV D, D3887-041 REV E SHEETS 1,2,5,7,8,10,11 IPP RevA: New issue DD verified by:EC IPP rev B 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 17.05.19 as per dwg D3887 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	4/20/20		0.00	0.25	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	Handfinish - 1-1 Chemical-B4B	1 pcs	4/20/20		0.00	0.83	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		
							Handfinish - 1 - 11 - B4B		
							Handfinish - 1 - 12 - B4B		
							Handfinish - 1 - 13 - B4B		
							Handfinish - 1 - 14 - B4B		
							Handfinish - 1 - 15 - B4B		
							Handfinish - 1 - 16 - B4B		
							Handfinish - 1 - 17 - B4B		
							Handfinish - 1 - 18 - B4B		
							Handfinish - 1 - 19 - B4B		
							Handfinish - 1 - 20 - B4B		
							Handfinish - 1 - 21 - B4B		
							Handfinish - 1 - 22 - B4B		



Container No: S198604



Part: D119-646-041

Job No: 197064

Serial No/Batch: S198604

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/04/17, TC STC LoA P.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

121 QC 7	1 pcs	4/20/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
122 QC 5	1 pcs	4/20/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
130 Skidtubes - 2 - B4B	1 pcs	4/20/20	0.00 1.54	QC 5 - 30	
				QC 5 - 40	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
135 QC 5	1 pcs	4/20/20	0.00 0.00	Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	

140 Skidtubes - 3 - B4B	1 pcs	4/20/20	0.00 1.47	QC 5 - 40	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	ML/LA
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
150 QC 5	1 pcs	4/20/20	0.00 0.00	Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	3 BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
QC 5 - 30					
QC 5 - 40					
160 Skidtubes - 4 - B4B	1 pcs	4/20/20	0.00 1.61	Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BR
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 5	1 pcs	4/20/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
QC 5 - 40					
180 QC 10	1 pcs	4/20/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	DAS
				QC 10 - 43	24
				QC 10 - 50	9-89
				QC 10 - 58	
				QC 10 - 9	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	4/20/20	0.00 0.83	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	SEP 11 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Powdercoat - 1 White Gl(A)- B4B	1 pcs	4/20/20	0.00 0.22	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
210 QC 3	1 pcs	4/20/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	

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						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	BE819-10-04.
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
220 Handfinish - 4-1-Assembly-B4B	1 pcs	4/20/20	0.00 3.83			Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	BE819-10-04.
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
						Handfinish - 4 - 1 - B4B	
240 Handfinish - 4-2-Assembly-B4B	1 pcs	4/20/20	0.00 2.00			Handfinish - 4 - 10 - B4B	BE819-10-04.
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
						Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	
245 QC 5	1 pcs	4/20/20	0.00 0.00			QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	

DAS
59
9-89

6/27/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

260 Packaging 3-1 - Stock - B4B	1 pcs	4/20/20	0.00 0.00	QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	OCT 09 2019
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
265 DC - 1 - B4B	1 pcs	4/20/20	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
270 QC 21 - FG	1 pcs	4/20/20	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of
 Descriptions: ends and scribe batch#

- 120 - (Chemical Conversion Coat per QSI005 4.1)
 121 - (QC7-Inspect Chemical Conversion Coat)
 122 - QC5- Inspect part completeness to step on W/O)
 130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R
 135 - (QC5- Inspect part completeness to step on W/O)
 140 - 1- Bend FWD end of tube using bender 1 and FOLIO 31 bend prog. D3887.***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887.***Verify measurment*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size.(verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Drill holes for wearpads using DT8931, open to 0.297". 11- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 12- Deburr and blow out chips from inside of tube.
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDELING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R 2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3887. 4- Deburr & Scribe batch # on Aft end of tube.
 170 - (QC5- Inspect part completeness to step on W/O) TEST FIT USING FIXTURE DT10091.
 180 - (QC10- Inspect visual per QSI004- ground welds)
 190 - Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME:

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OVEN TEMPERATURE: _____ FINISH TIME: _____

210 - (QC3- Inspect Part Finish)

220 - (Assemble as per dwg) 1-Install inserts as per Dwg D3887.

240 - (Assemble as per dwg) 1-Install inserts as per Dwg D3887. 2-Install wearpads, gaskets as per Dwg D3887. Put

Sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 520625 Sikaflex expire date:20/07 3-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lubebatch: 5138843 4 -Inspect for foreign objects as per QSI 024 5 -Install D2855-3 Cap and seal with Sikaflex.Clean excess adhesive. A/R Sikaflex-240/-291 520625 Sikaflex expire date: 20/07 6 -Install insert inD2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 520625 Sikaflexexpire date: 20/07 7- Wing Walk as per dwg and QSI Batch: 5209362

245 - (QC5- Inspect part completeness to step on W/O)

260 - Identify as per dwg & Stock Location: _____

265 - Photocopy bluefile & type labels per PPP D119-646-041 CHG005

270 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -I' Beam Tube 4"	1 pcs (1 ea)	110-Skidtubes - 1	<u>5168371</u>
D3885-1	Standard Web	1 pcs (1 ea)	130-Skidtubes - 2 - B4B	<u>5180313</u>
D2579	Crossbolt Spacer	2 pcs (2 ea)	140-Skidtubes - 3 - B4B	<u>5097840</u>
D2855-5	Cap	1 pcs (1 ea)	160-Skidtubes - 4 - B4B	<u>5002018</u>
D3681-1	Spacer	12 pcs (12 ea)	160-Skidtubes - 4 - B4B	<u>5211030</u>
D3903-1	Spacer	12 pcs (12 ea)	180-Skidtubes - 4 - B4B	<u>5211415</u>
ALS4-1032-130	Rivnut	33 Ea (33 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5057257</u>
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5192155</u>
AN3C4A	Bolt	6 Ea (6 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5218780</u>
AN3C5A	Bolt	26 Ea (26 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5216215</u>
D2855-3	Cap	1 pcs (1 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5126403</u>
D3492-5	Plug	24 pcs (24 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5197670</u>
D3672-1	Washer, Phenolic	2 pcs (2 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5164008</u>
D3847-1	Wearpad	5 pcs (5 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5211374</u>
D3847-11	Wearpad	1 pcs (1 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5136646</u>
MS24694-C52	Screw	2 Ea (2 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5067269</u>
NAS1149C0332R	Washer (AN860C10L)	32 Ea (32 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5193136</u>
NAS1611-005	O-Ring	24 Ea (24 ea)	240-Handfinish - 4-2-Assembly-B4B	<u>5194425</u>

M.H. 012258

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2500-1-190	1	83	0
130-Skidtubes - 2 - B4B	D3885-1	1	20	0
140-Skidtubes - 3 - B4B	D2579	2	93	0
160-Skidtubes - 4 - B4B	D2855-5	1	41	0
	D3681-1	12	84	0
	D3903-1	12	79	0
240-Handfinish - 4-2-Assembly-B4B	ALS4-1032-130	33	7,265	0
	ALS4-1032-225	1	915	0
	AN3C4A	6	1,357	0
	AN3C5A	26	962	0
	D2855-3	1	78	0
	D3492-5	24	186	0
	D3672-1	2	1,633	0
	D3847-1	5	21	0
	D3847-11	1	8	0
	MS24694-C52	2	60	0
	NAS1149C0332R	32	4,682	0
	NAS1611-005	24	454	0

Part Specifications

Specifications could not be found.

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SPECIFICATION CONTROL DRAWING

D2500-1-XXX EXTRUSION & D2500-3-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI

MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI

MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART BIN USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: D2500-1 = 0.143 lb/in, D2500-3 = 0.066 lb/in

8) FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG). D2500-1 EXTRUSION MANUFACTURED FROM:

- A) BON L DIE # 887105 -> PREFERRED
- B) CARADON MIDEAST DIE # PAH-28030
- C) CARADON MTL DIE # MH-18668

9) FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG). D2500-3 EXTRUSION MANUFACTURED FROM:

- A) CARADON INDALEX DIE # MS-18867

SHOP COPY

RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 197064

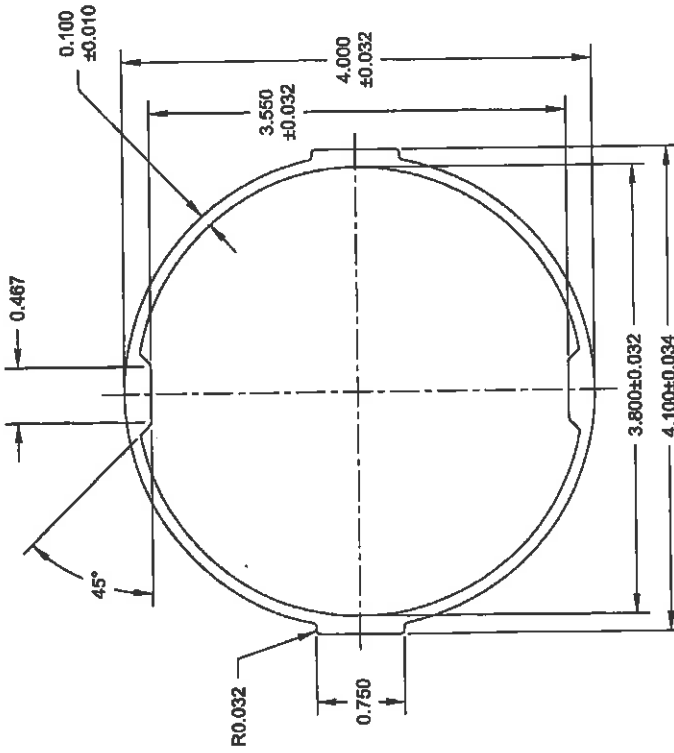
JUL 04 2019

RELEASED
2010-02-02

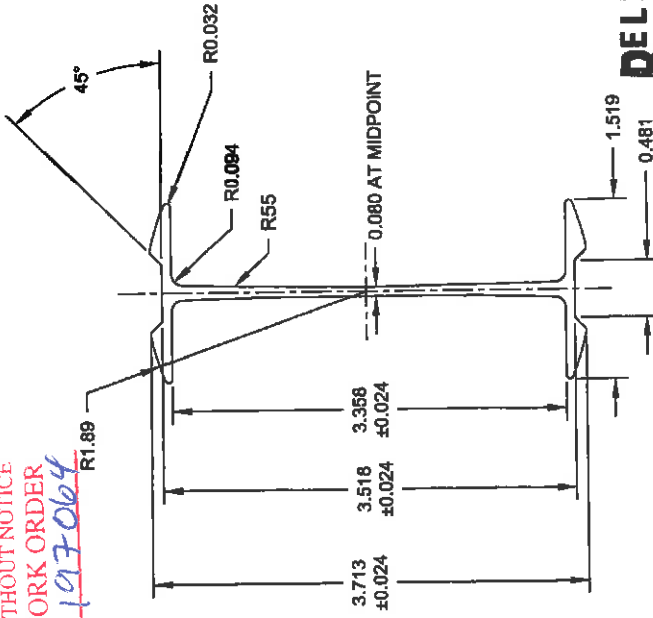
H	REDRAW & REFORMAT DWG; CORRECT BON L DIE #	CP	09.07.16
G	ADD DIE NUMBERS & DIMS IN INCHES' NOTES	PH	07.04.17
F	CHANGE MAT. TO 6061-T6	DS	97.09.20
E	CHANGE MATERIAL TEMPER	DS	98.10.24
D	ADD MATERIAL PROPERTIES	DS	98.10.07
C	ADD D2500-3 WEB	BW	98.04.26
B	CHANGE INTERNAL WEB	DS	98.03.24
A	NEW ISSUE	DS	98.03.19
REV.	DESCRIPTION	BY	DATE
DESIGN	4		
DRAWN	4		
CHECKED	4		
MFG. APPR.	4		
APPROVED	4		
DE APPR.	4		
DATE	09.07.16		
DART AEROSPACE LTD			
HAWKESBURY, ONTARIO, CANADA			
REV. H			
DRAWING NO. D2500			
SHEET 1 OF 2			
TITLE			
EXTRUSION			
SCALE			
NTS			
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JUL 04 2019



D2500-1



D2500-3

RELEASED
 2010-07-02

DESIGN	4	DART AEROSPACE LTD	REV. H
DRAWN	4	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 2
CHECKED	BT	DRAWING NO.	SCALE
MFG. APPR.		D2500	NTS
APPROVED		TITLE	
DE APPR.		EXTRUSION	
DATE	09.07.16		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				
		Completed By _____			
		Lead hand / Supervisor _____			
		QC / QA Coordinator _____			